

Date: Thursday, 7/3/2008 3:32:26 PM
 User: Kim Johnston

Process Sheet

31

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DART 13-MAN 3-POINT SHOULDER HARNESS KIT
 Job Number : 40226
 Estimate Number : 12865
 P.O. Number :
 This Issue : 7/3/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D412702041B
 First Issue : 1/1 Type : SMALL /MED FAB Drawing Number : IIN D412-702 REV E
 Previous Run : 32760 Drawing Revision : E
 Material :
 Due Date : 7/30/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 08 07 04
 Comment : est rev A 07.05.10 new issue EC
 est rev C 07.06.20 changed AN44 4A to AN444A EC
 Est Rev:D 07-07-06 As per Rev E JLM
 Est Rev:E 08-03-31 now at chg003 ECN1150 DD verified by:

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

-DC

DOCUMENT CONTROL



JLD 08.7.08



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D412-702-041B CHG003

Soder/W

2.0

D412702059

Grommet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GROMMET KIT

batch: 40187

SQ

3.0

D412702101B

Harness Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HARNESS ASSEMBLY

batch: 32484

SQ

4.0

D412702103B

Harness Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HARNESS ASSEMBLY

batch: 32485

SQ

5.0

D412702105B

Harness Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

HARNESS ASSEMBLY

batch: 32486

8/7/10

SQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 40226

Part Number: D412702041B

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D412702107B

Harness Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

HARNESS ASSEMBLY

batch: 32487

SP

7.0

D412702109B

Harness Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

HARNESS ASSEMBLY

batch: 32488

SP

8.0

D412702111B

Harness Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HARNESS ASSEMBLY

batch: 32609

SP

9.0

D412702113B

Harness Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HARNESS ASSEMBLY

batch: 32610

SP

10.0

D412702115B

Harness Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

HARNESS ASSEMBLY

batch: 32491

SP

11.0

D412702117B

Harness Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

HARNESS ASSEMBLY

batch: 32492

SP

12.0

D35421

Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BRACKET

batch: 38296

8/7/10

(X)

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Drawing Name: DART 13-MAN 3-POINT SHOULDER HARNESS KIT

Job Number: 40226

Part Number: D412702041B

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D35711

Guide



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

GUIDE

batch: 31868

B40222x1

* new Batch #

54

14.0

D35713

Guide



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GUIDE

batch: 31869

54

15.0

D3572041

Guide Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GUIDE ASSEMBLY

batch: 31870

54

16.0

D3578041

Doubler



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

DOUBLER

batch: 32483

54

17.0

D3610041

Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BRACKET

batch: 32607

54

18.0

D36181

CAP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CAP

batch: B 32426

54

19.0

AN410A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch: 101291

8/7/10

(X)

54

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 40226

Part Number: D412702041B

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN416A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch: 18499

SP

21.0

AN425A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

batch: 104438

SP

22.0

AN444A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

bolt

batch: 104806

SP

23.0

MS24693S274

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: 104214

SP

24.0

MS24694S56

SCREW



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

SCREW

batch: 14198

SP

25.0

MS24694S58

Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

batch: 11735

SP

26.0

MS24694S60

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screw

batch: 11706

8/7/10

SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 40226

Part Number: D412702041B

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN960JD416

Washer



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)

Washer

batch: 107939

SCD

28.0

AN960JD416L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: 103962

SCD

29.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: 107478

SCD

30.0

CR321244

Cherry Rivet



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Cherry Rivet

batch: 16896

8/7/10

SCD

31.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/8/10

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-041B CHG003

Location:

PPP Rev:

Rev C

8/8/10

33.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/10

Job Completion



08.07.10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
X					D412-702-041B	Dart 13-Man 3-Point Shoulder Harness Kit
	X				D412-702-043B	Dart 5-Man 3-Point Forward Facing Shoulder Harness Kit
		X			D412-702-045B	Dart 4-Man 3-Point Aft Facing Shoulder Harness Kit
			X		D412-702-047B	Dart 4-Man 3-Point Side Facing Shoulder Harness Kit
				X	D412-702-049B	Dart 1-Man 3-Point Forward Shoulder Harness Kit
1	1		1	1	D412-702-059	GROMMET KIT
2	1		1		D412-702-101B	HARNESS ASSEMBLY
1*	1*		1*		D3573-7	ADAPTER
1*	1*		1*		D3579-046	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
2	1		1		D412-702-103B	HARNESS ASSEMBLY
1*	1*		1*		D3573-8	ADAPTER
1*	1*		1*		D3579-045	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1	1			1	D412-702-105B	HARNESS ASSEMBLY
1*	1*			1*	D3573-1	ADAPTER
1*	1*			1*	D3579-046	SHOULDER HARNESS
1*	1*			1*	K6.2	CLIP
4*	4*			4*	MS24693S273	SCREW
4*	4*			4*	AN960JD10LL	WASHER
4*	4*			4*	MS21042L3	NUT
1	1				D412-702-107B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-046	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT
1	1				D412-702-109B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-045	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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 WITHOUT NOTICE
 WORK ORDER
 NO. 40236

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
2		2			D412-702-111B	HARNESS ASSEMBLY
1*		1*			D3570-1	BRACKET
1*		1*			D3579-047	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
2		2			D412-702-113B	HARNESS ASSEMBLY
1*		1*			D3570-2	BRACKET
1*		1*			D3579-048	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
1			1		D412-702-115B	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-046	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
1			1		D412-702-117B	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-045	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
2	2				D3542-1	BRACKET
7	3		4	1	D3571-1	GUIDE
2	2				D3571-3	GUIDE
2		2			D3572-041	GUIDE ASSEMBLY
12	6		6	2	D3578-041	DOUBLER
2	2				D3610-041	BRACKET
2	2				D3618-1	CAP
4	4				AN4-10A	BOLT
2		2			AN4-16A	BOLT
4		4			AN4-25A	BOLT
2	2				AN4-44A	BOLT
2	2				MS24693S274	SCREW
3	3			1	MS24694S56	SCREW
10	2		8		MS24694S58	SCREW
1	1			1	MS24694S60	SCREW
26	6	20			AN960JD416	WASHER
4	4				AN960JD416L	WASHER
12	6	6			MS21042L4	NUT
24	12		12	4	CR3212-4-4	RIVET

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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 NO. 40226